

Work Order ID 66205

February 7, 2011 12:47:14 PM



Page 1

Item ID:	D4198-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Throttle Bellcrank Assembly, RH					
Start Date:	2/07/11	Start Qty:	2.00		Cust Item ID:	
Required Date:	2/18/11	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/02/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4198	<u>PAT PA2</u>								
100	Pick Kit	0.00							
Packaging	Memo	0.00	<u>Sh</u>	<u>11604/20</u>		<u>①</u>			
Packaging									
110		0.00							
Small Fab	Memo	0.00	<u>Sh</u>	<u>11604/20</u>		<u>①</u>			
Small Fab	assemble as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									



inspectors to PA2
Dwg only
8 11604/20

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66205

February 7, 2011 12:47:14 PM



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Item ID:	D4198-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Throttle Bellcrank Assembly, RH					
Start Date:	2/07/11	Start Qty:	2.00		Cust Item ID:	
Required Date:	2/18/11	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

RD 2334

U 1106.09

POSITIVE RECALL
EFFECTIVE 11-02-07 AUTH U
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

February 7, 2011 12:47:13 PM

Work Order ID: 66205

Parent Item: D4198-043

Parent Item Name: Throttle Bellcrank Assembly, RH




Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4198-3 		Manufactured	No			100	Each	0.0000	1	2			
Tube, RH													
D4198-5 		Manufactured	No			100	Each	0.0000	1	2			
Bellcrank													
MS20470AD4-20 		Purchased	No			100	Each	542.0000	2	4			

Rivet

CR3523-44

Ad 11.04.20

Location	Loc Qty	Loc Code
ST320	542	
1071	542	
		4

B 10-008151 (EAGLE) 4.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

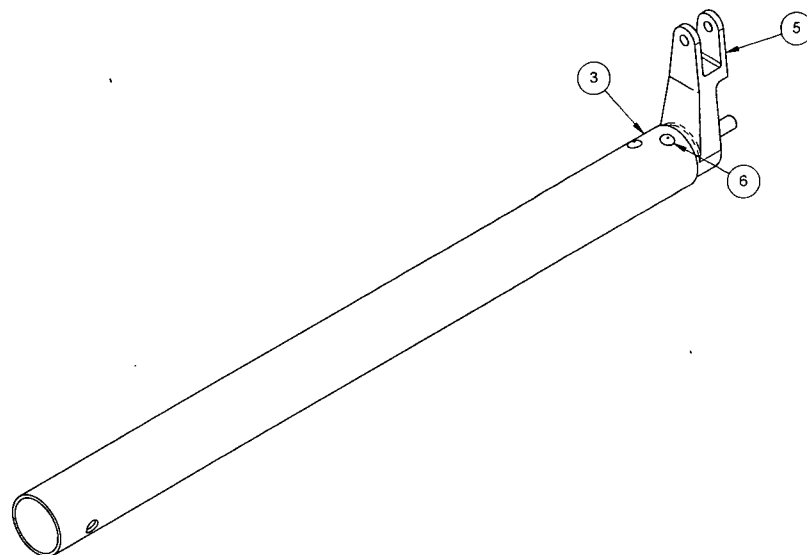
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

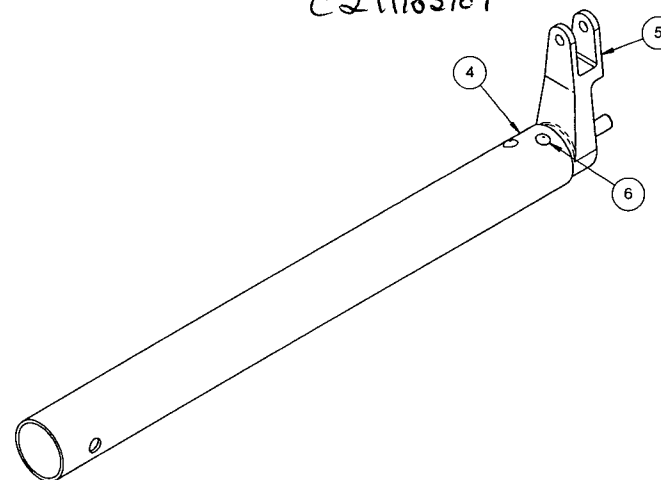
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4198-041	LH THROTTLE BELLCRANK ASSEMBLY
2		X	D4198-043	RH THROTTLE BELLCRANK ASSEMBLY
3	1		D4198-1	TUBE, LH
4		1	D4198-3	TUBE, RH
5	1	1	D4198-5	BELLCRANK
6	2	2	MS20470AD4-20	RIVET



D4198-041 LH THROTTLE BELLCRANK ASSEMBLY



D4198-043 RH THROTTLE BELLCRANK ASSEMBLY

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NO. 66205
CZ11102107

PRELIMINARY ISSUE

[Signature] 10.11.03

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: (-041) 1.28 lbs
(-043) 1.10 lbs

PA2	NEW ISSUE		10.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.03		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

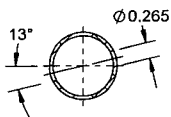
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D4198

REV. PA2
SHEET 1 OF 4

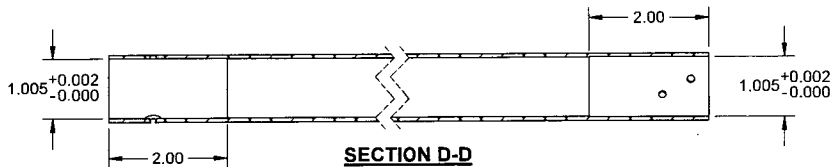
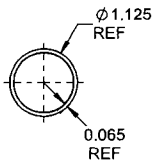
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THROTTLE BELLCRANK

SCALE
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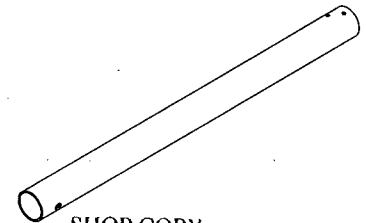
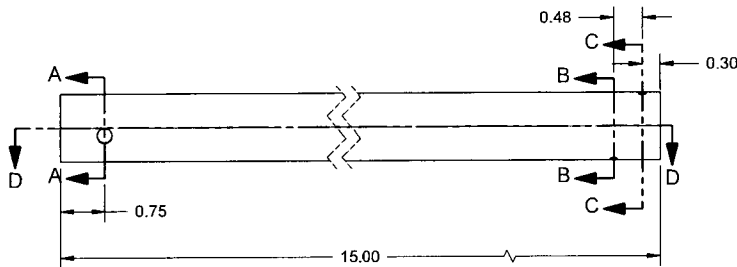
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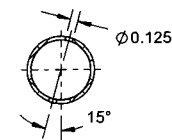
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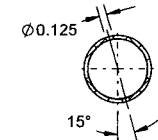
SECTION D-D



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NO. 66205



SECTION B-B



SECTION C-C

D4198-1 TUBE, LH

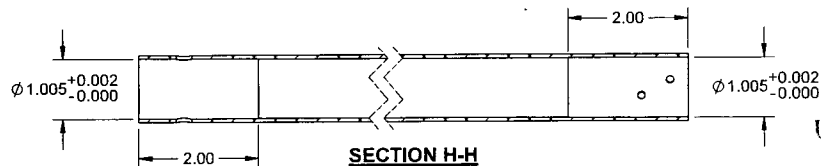
PRELIMINARY ISSUE

10.11.03

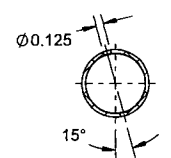
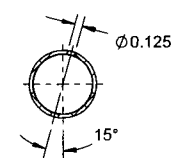
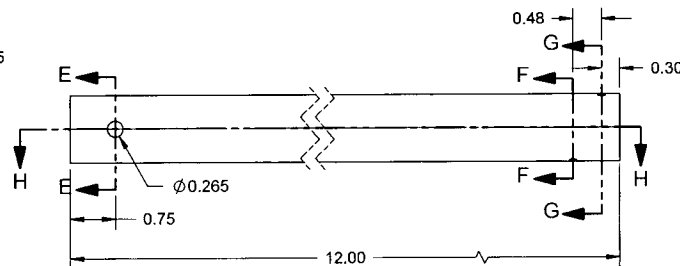
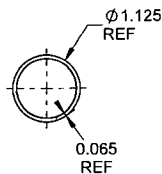
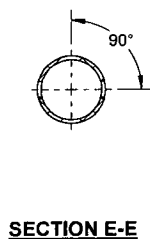
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, OD $\phi 1.125$ X 0.065 WALL THICKNESS
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC M304TR1.158W.049
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4198	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		THROTTLE BELLCRANK	NTS
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NO. 66205



SECTION F-F

SECTION G-G

D4198-3 TUBE, RH

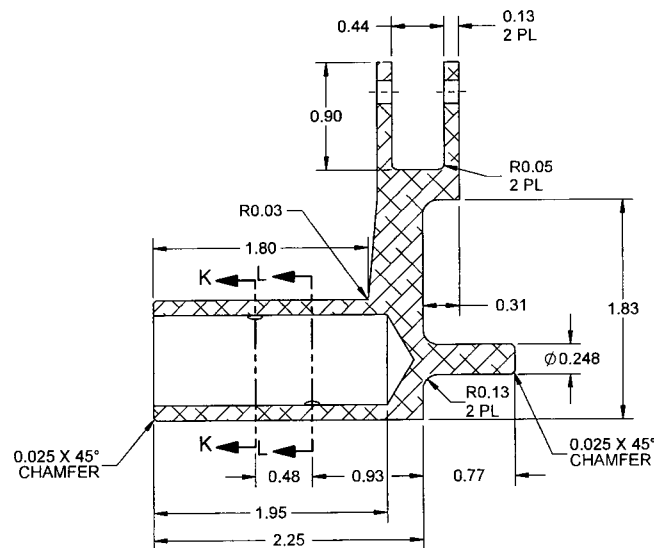
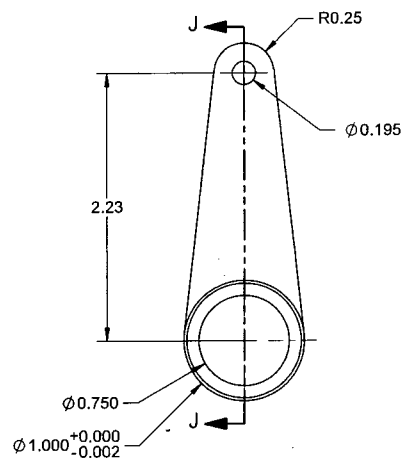
PRELIMINARY ISSUE

10.11.03

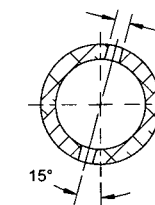
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, OD $\phi 1.125$ X 0.065 WALL THICKNESS
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC M304TR1.158W.049
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.71 lbs

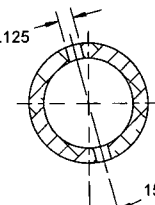
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CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4198	SHEET 3 OF 4
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DE APPR.		THROTTLE BELLCRANK	NTS
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SECTION J-J

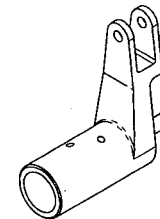


SECTION K-K



SECTION L-L

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D4198-5 BELLCRANK

PRELIMINARY ISSUE

10.11.03

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A276
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
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